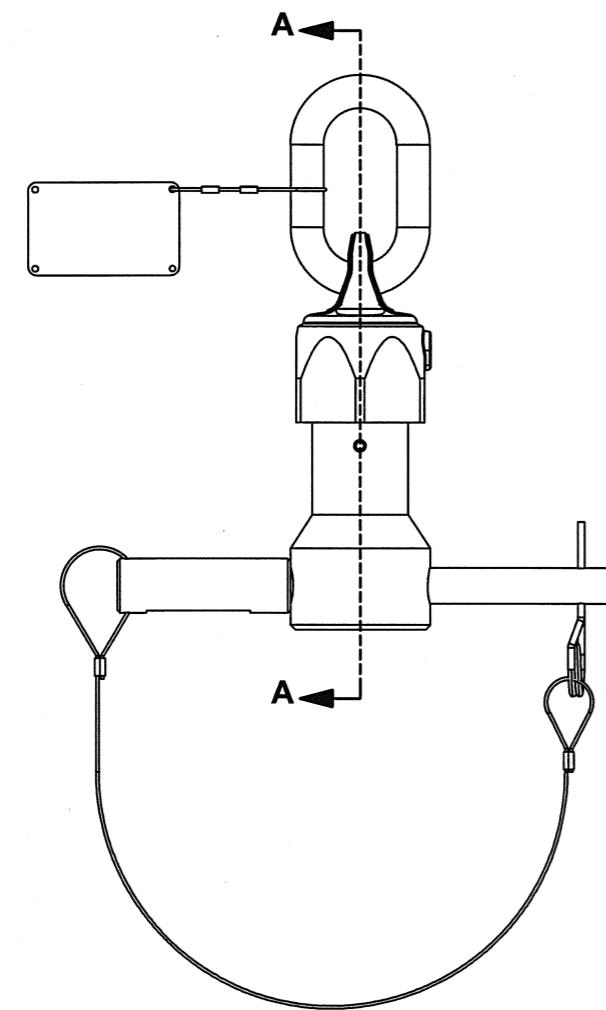


ITEM #	QTY	PART #	PART TITLE
-01	1	RBEM12669/P-1-01	BODY
-03	1	RBEM12669/P-1-03	PIN
4	1	RB41011	DART PLACARD
5	1	McMaster#97855A260 OR EQUIV	BLACK PHOSPHATE STEEL SLOTTED SPRING PIN 1/4" DIA. X 2" LG.
6	1	McMaster#98335A790 OR EQUIV	ZINC PLATE STEEL COTTER PIN FOR 5/8" TO 1" CLEVIS PIN DIA.
7	4	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
8	AR	CARR-LANE #CL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.
9	1	ACTEK#44124 OR EQUIV	10,000 LBS CAPACITY 1"-8 X 1-1/2" LG. ULTRA LIFTING RING



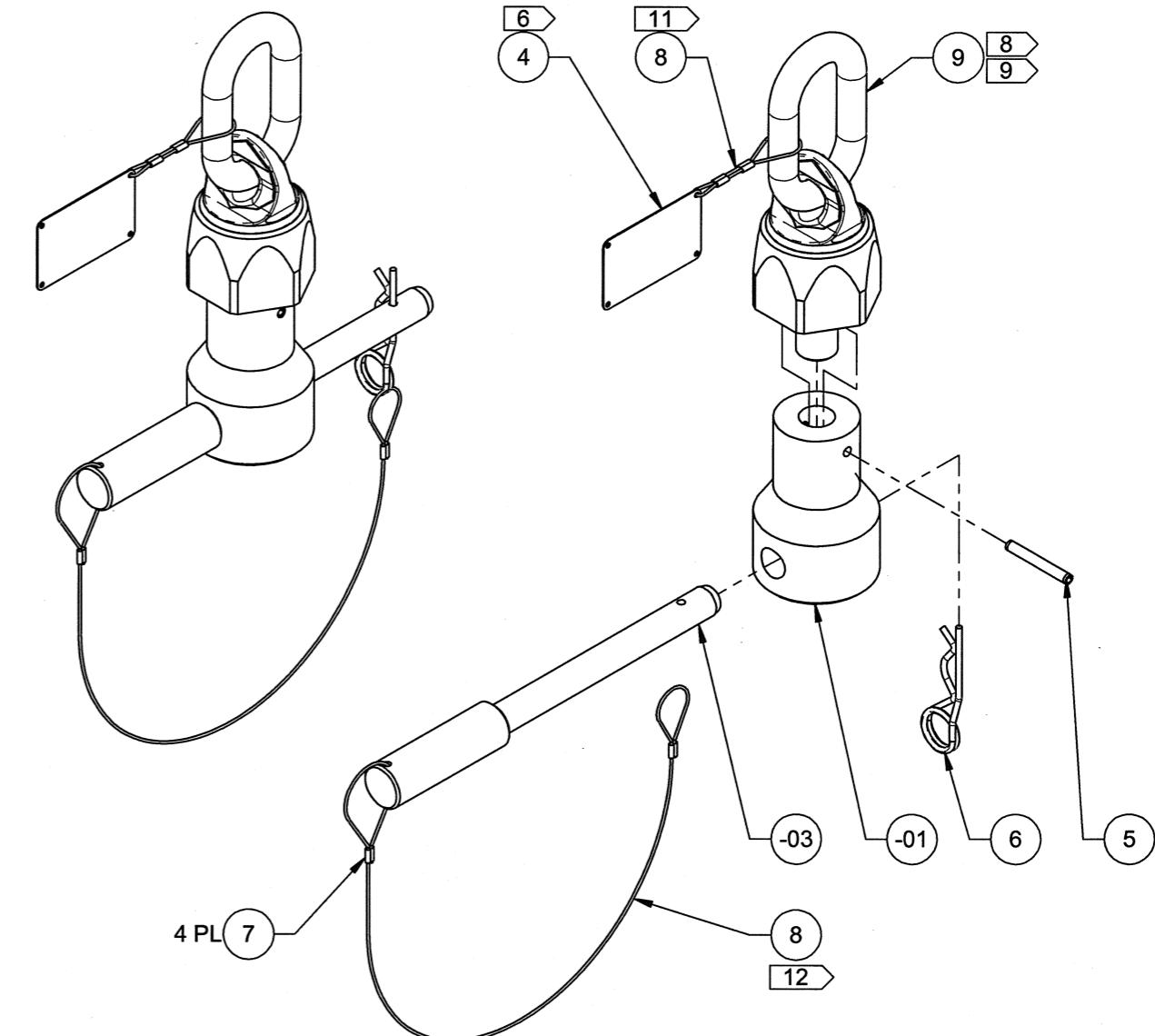
SECTION A-A

RBEM12669/P-1 HOISTING TOOL ASSEMBLY

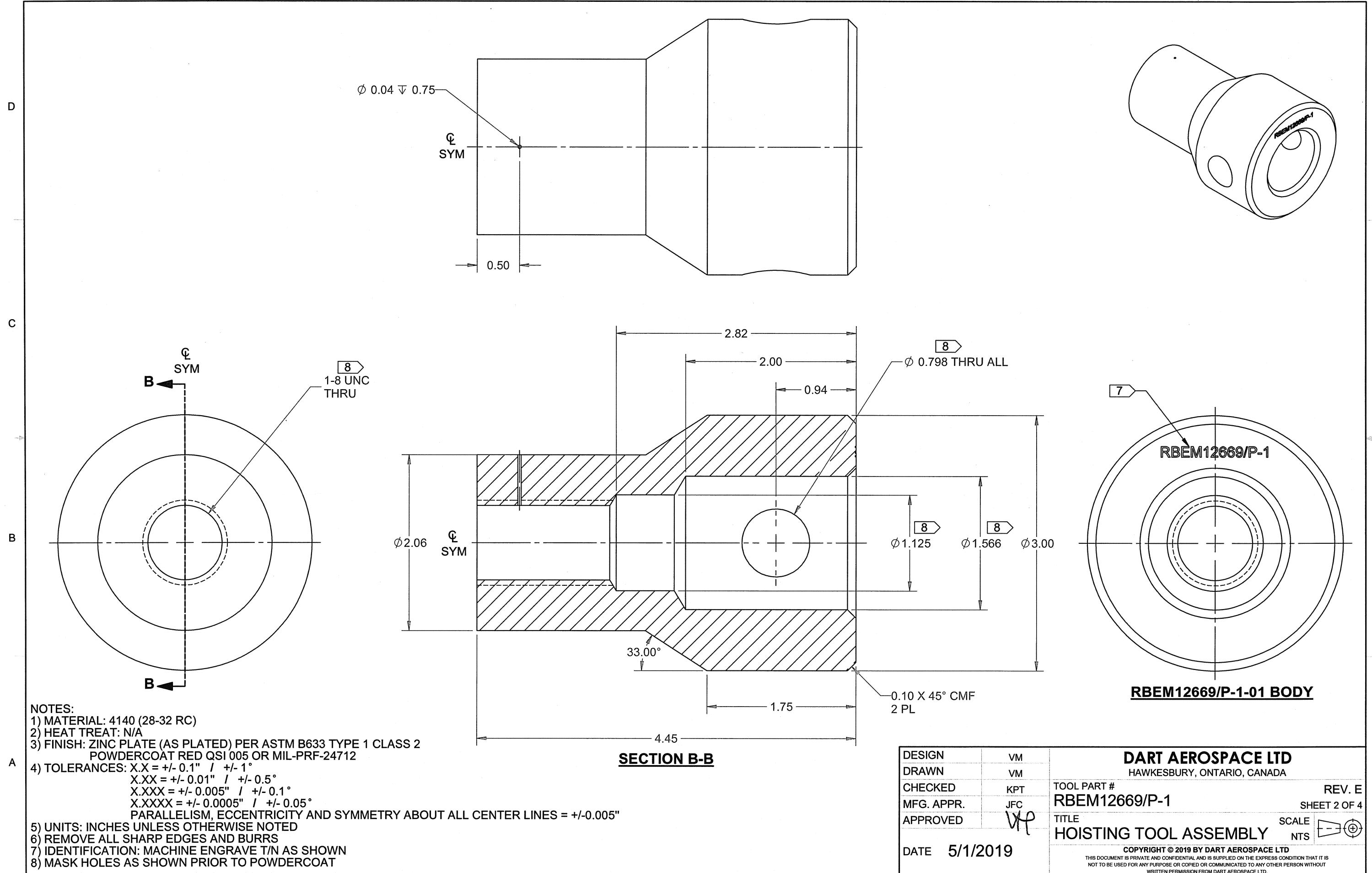
14

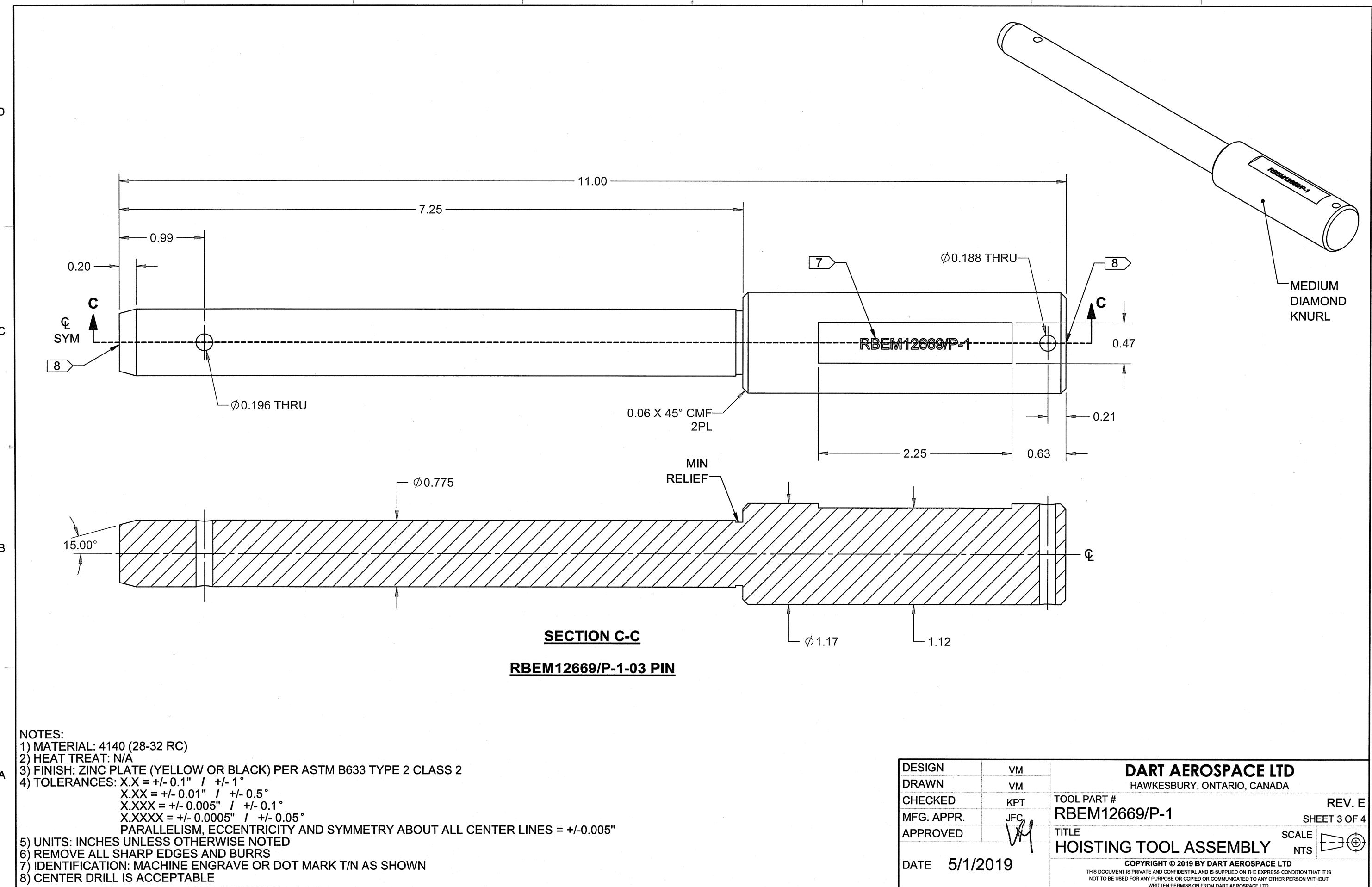
NOTES:  
 1) MATERIAL: N/A  
 2) HEAT TREAT: N/A  
 3) FINISH: N/A  
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
     X.XX = +/- 0.01" / +/- 0.5°  
     X.XXX = +/- 0.005" / +/- 0.1°  
     X.XXXX = +/- 0.0005" / +/- 0.05°  
     PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

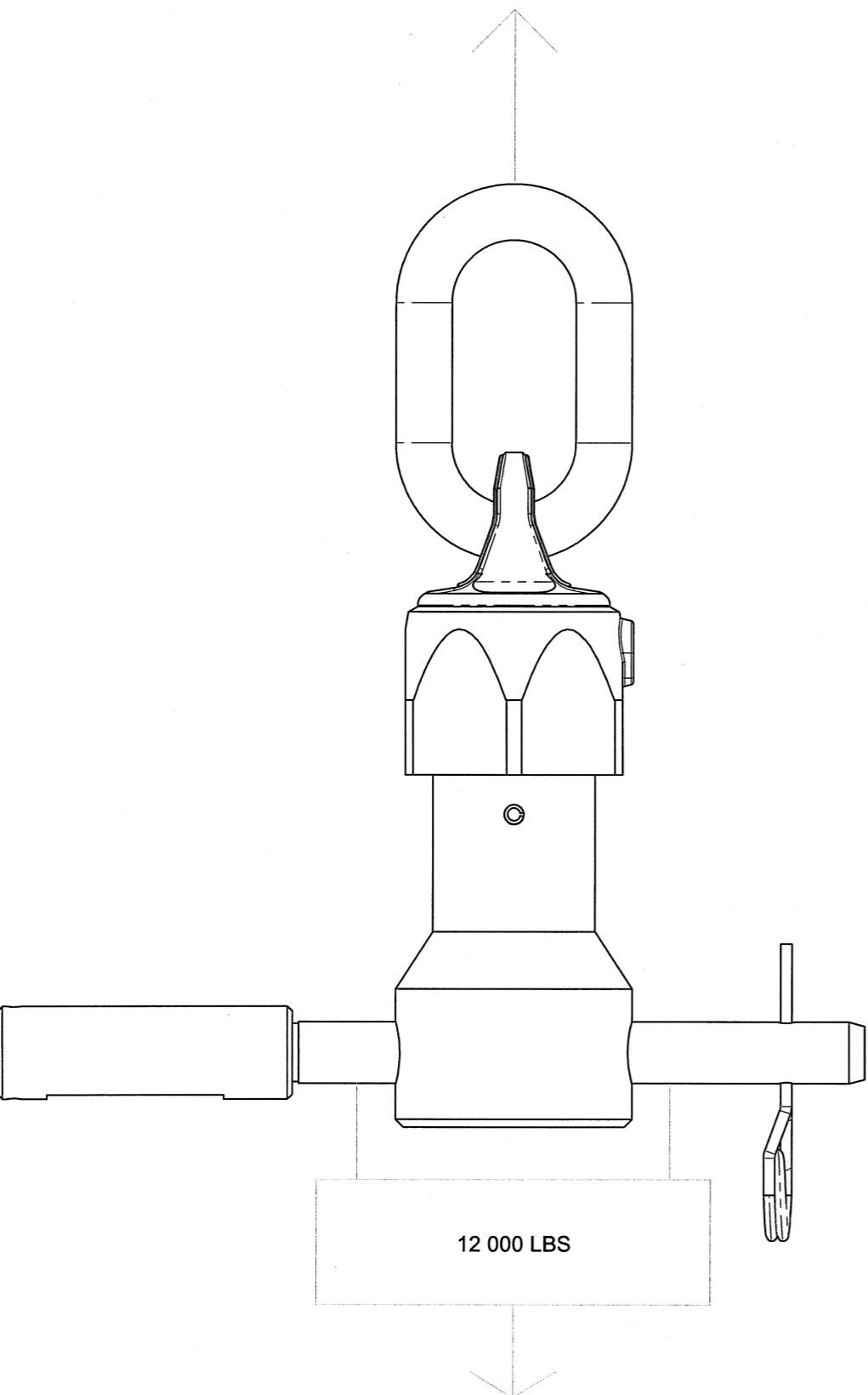
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
 6) IDENTIFICATION: ENGRAVE THE TOOL P/N, S/N, AND "SWL: 3T WEIGHT TESTED AT 12,000 LBS" ON THE DART PLACARD WHERE INDICATED  
 7) ASSEMBLE AS SHOWN  
 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 9 THEN ASSEMBLE WITH ITEM -01, AND REMOVE EXCESS  
 9) INSTALL ITEM 9 HAND TIGHT  
 10) TRANSFER DRILL HOLE THROUGH ITEMS -01 AND 9 AS SHOWN, AND PRESS ITEM 5 CENTERED THROUGH ITEMS -01 AND 9  
 11) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1"  
 12) ASSEMBLED LANYARD LENGTH MUST BE 12" +/- 1", LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM -03  
 13) REMOVE ALL SHARP EDGES AND BURRS  
 14) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



E	SEE PREVIOUS PDFs FOR OLDER REVs TEMPLATE UPDATE PER DART HAWKESBURY STANDARDS ITEM -15 SET SCREW McMaster#92695A405 REPLACED BY ITEM 5 McMaster#97855A260 DIMENSION 5/16-18 UNC - 1B $\nabla$ .63 CHANGED FOR Ø0.250 +0.005 / -0 THRU ALL ITEM -13 DELETED ITEM -01 DIMENSION .942 CHANGED FOR 0.94, MATERIAL 1018/1020 CR POWDER COAT RED CHANGED FOR 4140 (28-32 RC) ZINC PLATE TYPE 1 AND POWDER COAT, NOTE 8 ADDED, ENGRAVING S/N AND "MADE IN USA" REMOVED, PILOT HOLE 0.04 ADDED ITEM -03 DIMENSION 5.00 CHANGED FOR 7.25, DIMENSION 9.25 CHANGED FOR 11.00, DIMENSION Ø.55 $\nabla$ .75 REMOVED, DIMENSION .08 AND Ø.74 REMOVED AND REPLACE BY "MIN RELIEF" NOTE, DIMENSION 0.20 AND 15.0° ADDED FOR CHAMFER, MATERIAL 4140/4142 HEAT TREAT 28-34 RC ZINC PLATE TYPE 1 CHANGED FOR 4140(28-32 RC) BLACK OXIDE			19-714 VM
	REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	VM			
CHECKED	KPT			
MFG. APPR.	JFC			
APPROVED	WJ			
TOOL PART #	<b>RBEM12669/P-1</b>			REV. E
DATE	5/1/2019			SHEET 1 OF 4
TITLE	<b>HOISTING TOOL ASSEMBLY</b>			SCALE NTS
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INSPECTION & TESTING PROCEDURE FOR THE RBEM12669/P-1,  
HOISTING TOOL ASSEMBLY. THIS TOOL IS DESIGNED FOR LIFTING THE  
EC135, H135, AND EC635 HELICOPTER.  
THIS HOISTING TOOL SHOULD BE INSPECTED BEFORE AND AFTER  
EACH USE.

**REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED  
OF DAMAGE BEFORE USING!**

**FIRST ARTICLE WEIGHT TEST**

1. AFTER INSPECTION, PLACE HOISTING TOOL ON AN OVERHEAD LIFTING DEVICE. ATTACH HOISTING TOOL TO AN APPROPRIATE TEST WEIGHT TEST OF 12,000 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, DISTORTION OR DAMAGE.
3. REMOVE WEIGHT AND RE-INSPECT, CHECKING FOR ANY CRACKS, DEFLECTION, DISTORTION OR DAMAGE.

INSPECTOR: \_\_\_\_\_  
TESTER: \_\_\_\_\_  
S.N.: \_\_\_\_\_  
DATE: \_\_\_\_\_

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. E
MFG. APPR.	JFC	RBEM12669/P-1	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	
DATE 5/1/2019		SCALE NTS	

**HOISTING TOOL ASSEMBLY**

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